

Date: Tuesday, 5/23/2006 8:12:51 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 6" MIRROR
Job Number	: 27163		
Estimate Number	: 10101		
P.O. Number	: N/A	Part Number	: D2011101
This Issue	: 5/23/2006 S.O. No. : N/A	Drawing Number	: D2011 REV. F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: F
Previous Run	: 24967	Material	: N/A
Written By	: <u>SKA COMMENT BELOW</u>	Due Date	: 6/2/2006 Qty: 50 Um: Each
Checked & Approved By	: <u>06.05.23</u>		
Comment	Est: J 04.09.15 Added Steps 5-7 KJ/JLM Est: K 05.12.15 chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1309
 Purchase Grote Mirror P/N: 28043
 Possible supplier: UAP/NAPA
 Material release note required

CL 06/05/24 (50)

2.0	28043	MIRROR 6"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Mirror 6"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

SP. 06/05/29 (50)

4.0	D30141	Locknut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Locknut
 Pick:
 Qty Part Number Description Batch
 1 D3014-1 Lock nut B25021

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-05-30	3.	Add Qc G for receiving inspection permanent change	Inspected by	06-30			06-05-30

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/05/30	6	1 mirror broke when drilled holes	JB 06/05/30	Scrap + destroy	SB 06/06/08	06-06-08	JB 06/05/30	06-06-08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 27163

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer M3159

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill-mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291/-241adhesive per hole.

Qty Part Number Description Batch

9ml N/A

Sikaflex-291/-241

Expiry date

7/11/2006

8 M100900

H-19 06/06/01

4- Test assembly to 50lbs pull test after 24 hours

Start: 06:06:07 Time: 1400

Finish: 06:06:07 Time: 2h45

SAD 06:06:07

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST-24

Re 6/6/8

49

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/06/09

Job Completion



W 26.06.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

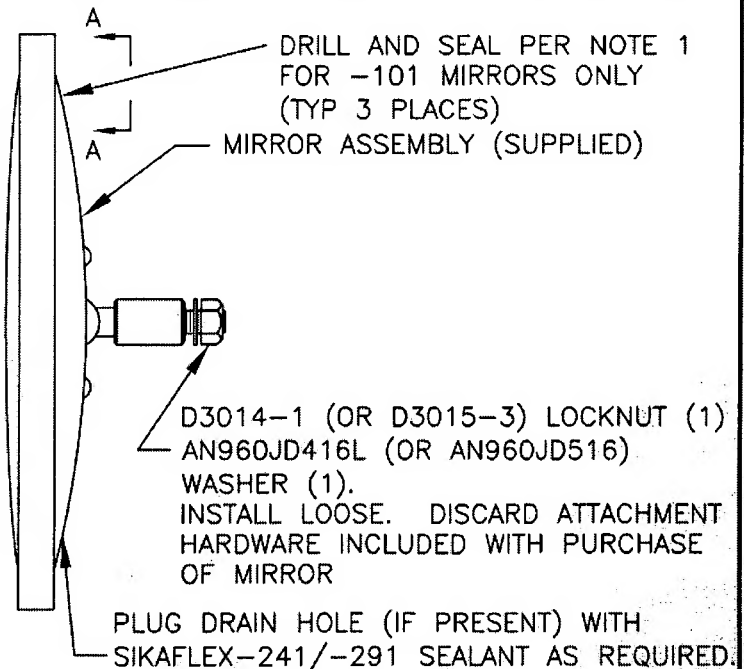
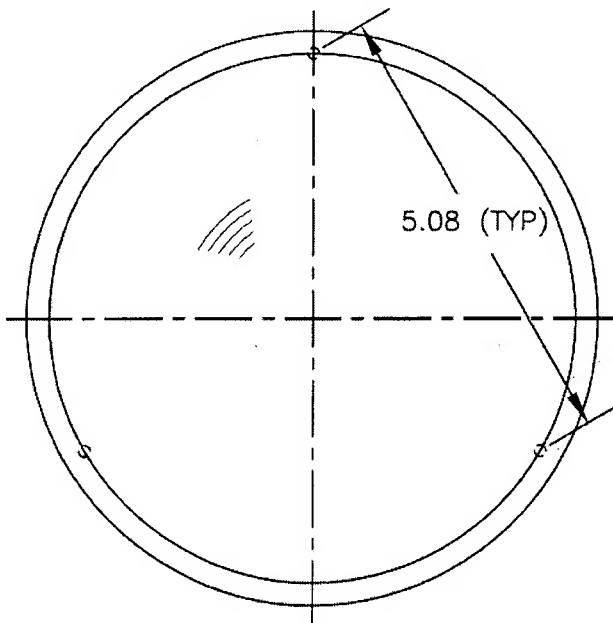
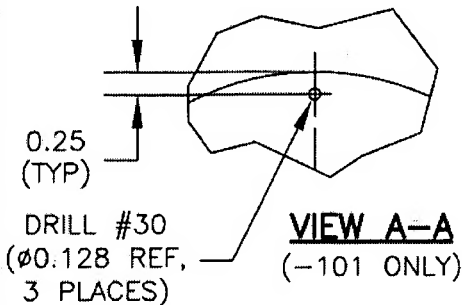
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10		TITLE MIRROR ASSEMBLY	SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	



QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

NOTES:

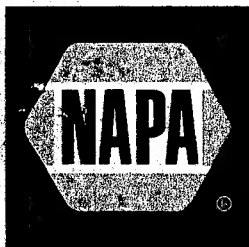
- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27163

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RELEASED
04.09.10



HAWKESBURY AUTO PARTS INC 5580GST#:

861597896RT0001

14 MAIN STREET WEST

EXC#:SU 6259 EXP:03/12/31

HAWKESBURY, ONT. K6A 2J2

DANGEROUS GOODS PERMIT

TEL:632-8575 FAX: 632-1539

EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS

CANUTEC 613-996-6666

ACCT #	SOLD TO	DATE	TIME	STORE #	EMP #	INVOICE NO.
01601	DART AEROSPACE LTD	5/24/06	16:46	06000407	31	120088
SR #	1270 ABERDEEN STREET	PURCHASE ORDER #		ATTENTION		
6	HAWKESBURY, ONTARIO	1309				
AD	K6A 1K7	TAX EXEMPTION: 6122-5207				
21		TERMS: NET 30 DAYS		CHARGE SALE		
		DELIVERY:				

PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
28043 ✓		GRD GROTE	✓ 50.00	41.140	16.820	841.00 T150
		DIRECT CONNECT PURO				
06/05/29						

REFUNDED BY _____

Subtotal

841.00

VERIFIED BY _____

Tax 7% GST ONLY

58.87

Tax 0%

0.00

SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL ----> CHARGE SALE

899.87